

**STATEMENT OF WORK  
FOR  
AN/SPS-48E OVERHAUL, ROTARY COUPLER PREMIER VERSION**

**1.0 Scope**

The contractor shall overhaul and repair AN/SPS-48E Pedestal Rotary Coupler Premier Version. This SOW covers the overhaul, repair and acceptance requirement.

**2.0 Applicable Documents**

SE110-UE-MDB-010/SPS-48E Overhaul and Repair Manual Antenna AN/SPS-48E  
ITT drawing 195196 Revision U

**3.0 Requirements**

The contractor shall inspect each system to determine the appropriate level of repair required. The contractor shall provide an inspection report via e-mail to Wright\_T@Crane.Navy.Mil. Acceptance of the report shall be the Government's direction to proceed with the recommended overhaul and repair.

3.1 The contractor shall inspect all piece parts for damage and war, replace duplex bearing set, support bearing, main carbon face seal, end seal, all O-rings, sliver graphalloy journal, dielectric bead supports, and type N contact. In addition each rotary coupler shall have paint stripped and corrosion damage repaired, plating-iridite/Contact Gold, and slip ring refurbished. Machine shop services shall be provided as required with painting to refurbish unit to ITT drawing 195956. Reassembly, electrical test, pressure test and leak tests will be accomplished to ITT drawing 195956. In addition the contractor shall complete all cleaning and inspection in accordance with SE213-UE-MDB-010/SP-48E Chapter 9 Section III.

3.2 The contractor shall perform all testing in accordance with SE213-UE-MDB-010SPS-48E

**3.3 Material and Chemical Substitution**

3.3.1 The contractor may substitute for materials and chemicals detailed in SE213-UE-MDB-010/SPS-48E Overhaul and Repair Manual that are no longer available or environmentally unacceptable. Documentation on which items have been substituted for shall be provided.

3.3.2 Sub-assemblies shall be deemed suitable for overhaul if all components are present and no major components (such as housings) are damaged beyond economical repair (such as a cracked housing).

**3.4 Exceptions to SE213-UE-MDB-010/SPS-48E**

Tools and equipment referenced in Para. 9-8.1 AND 9-9.1 may be substituted with equivalent equipment. Test set ups referenced in Para. 9-2, 9-3, 9-4, 9-5, 9-6 and 9-7 may be substituted with industry standards. High Power Testing referenced in Para. 9-8.10 is not required.

### 3.5 Acceptance

Acceptance shall be at Source by DCMC in accordance with Sections VI of the Overhaul and Repair Manual. The contractor shall provide notice of acceptance testing 5 days prior to test to :  
Wright\_T@Crane.Navy.Mil.